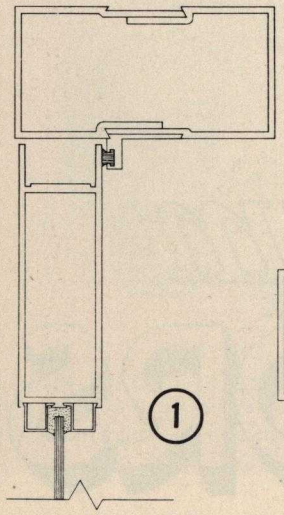
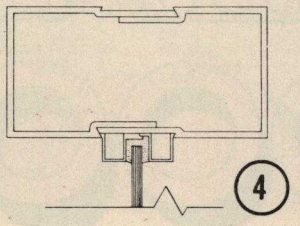
# VAMPCO® Aluminum DOORS

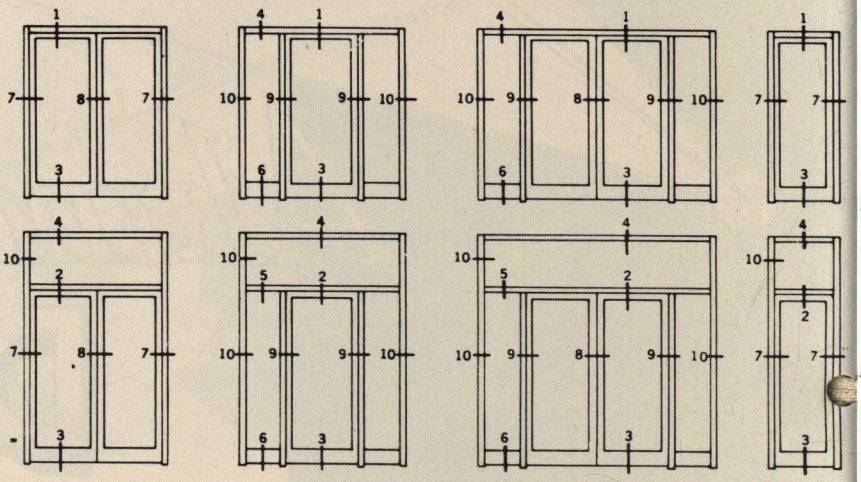
## VALLEY METAL PRODUCTS CO.

PLAINWELL
MICHIGAN

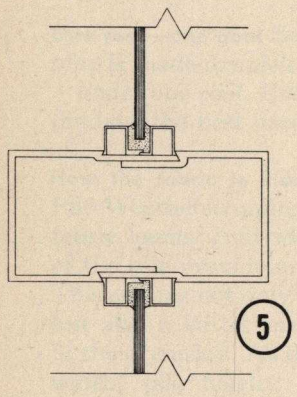
Subsidiary of
Mueller Brass Co.,
Port Huron, Mich.

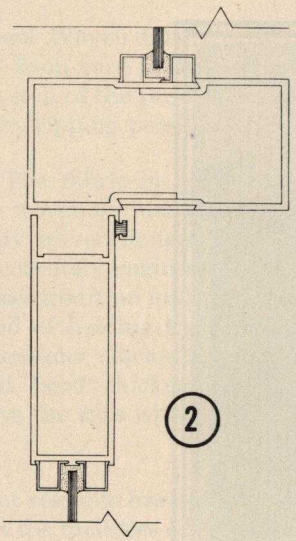


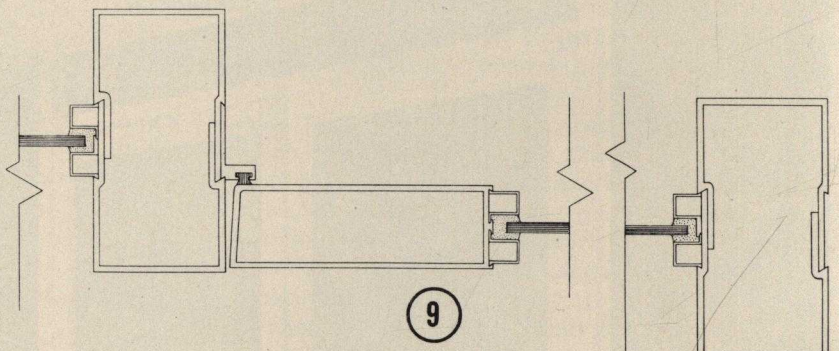



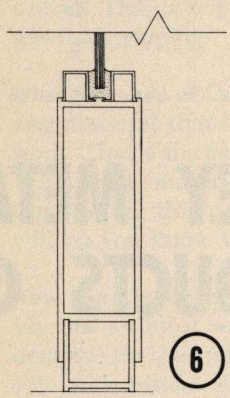



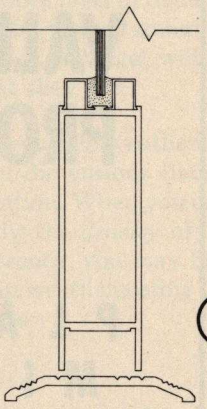

2¾" x 5½" FRAME

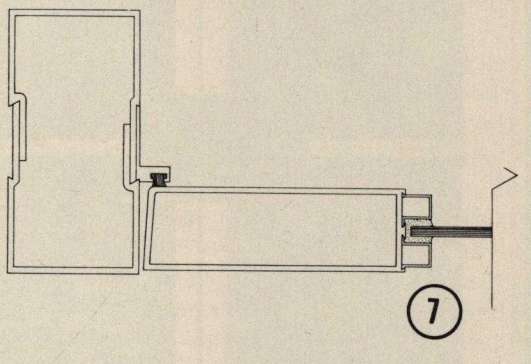


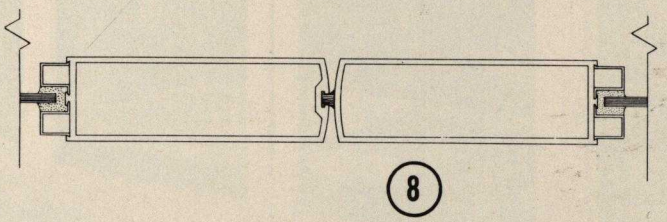




2¾" x 7½" and
2¾" x 9½" deep
Frames are also
available

## specifications

**WORK REQUIRED:** Aluminum narrow stile, wide stile or recessed panel, doors, frames, transoms, side lights and other items directly related shall be as manufactured by Valley Metal Products Company, Plainwell, Michigan.

**MATERIALS:** All sections shall be of extruded aluminum shapes of 6063-T5 alloy.
Section thickness shall be not less than .125" and glazing shapes shall not be less than .040".
All fastening parts such as screws, bolts, nuts, brackets and clips shall be fully protected against any chemical or electrolytic action.

**WORKMANSHIP:** All door corners shall be accurately joined and fitted to flush hairline joints. All corners shall be welded on unexposed sides. No weld marks such as halos, pitting or discoloration will be permitted on finish product.

All door welds shall thoroughly penetrate and produce a complete fusion of metals, and the corners shall be reinforced with a ⅜" aluminum rod with nuts on both ends giving an additional strength of not less than 20,000 P.S.I.

All fastening of glazing beads shall be of concealed type and no exposed screws shall be permitted.

Weatherstrip shall be of vinyl back pile cloth, securely held in place as provided in the extrusions of the doors and frames. The perimeter of the frames on single acting doors shall be weatherstripped as well as the meeting stile of double doors. Double acting doors shall be weatherstripped on the face of the stile on all outside stiles as well as the meeting stiles.

No surface application of weatherstripping will be permitted.

All cutouts, mortising, recesses or mill operation necessary for the installation of hardware shall be accurately made and where reinforcing is required, it shall be done with such material to insure adequate operation and strength.

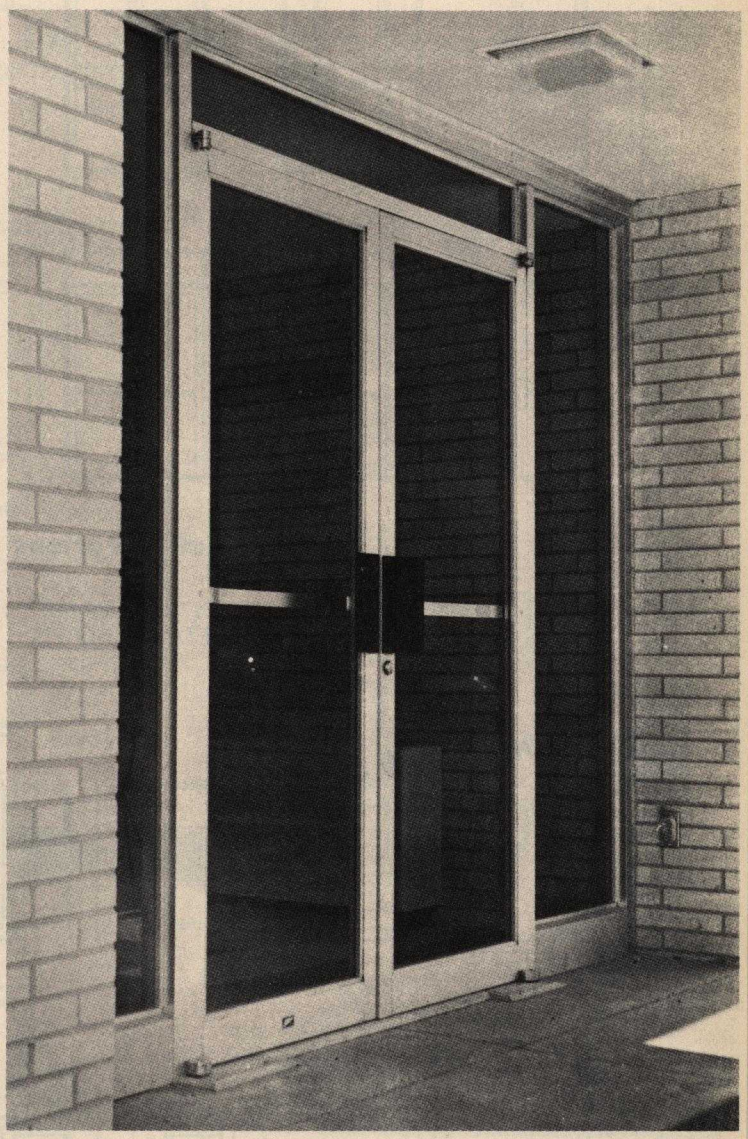
The complete assembly shall be fabricated in the factory to insure accurately fitted joints, proper fitting hardware. No field fabrication of frames will be permitted.

**FINISH:** All exposed surfaces shall be finished free of die marks, scratches, weld halos or surface blemishes and given an anodic oxide treatment in accordance with Alcoa specification "Alumilite 204 A1 R1". Recessed Door panel finish shall be Vamchrome applied color, #10 Ribbed Aluminum, Plastic Fabricate Coated, Wood veneer or plain Aluminum 204 finish.

**HARDWARE:** All hardware shall be furnished and installed by the door manufacturer. No field application will be permitted. Hardware finish shall closely match the finish of the doors.

**SHOP DRAWINGS:** Drawings shall be furnished for approval in triplicate of a scale that will show all details clearly and with all dimensions necessary for coordination and installation.

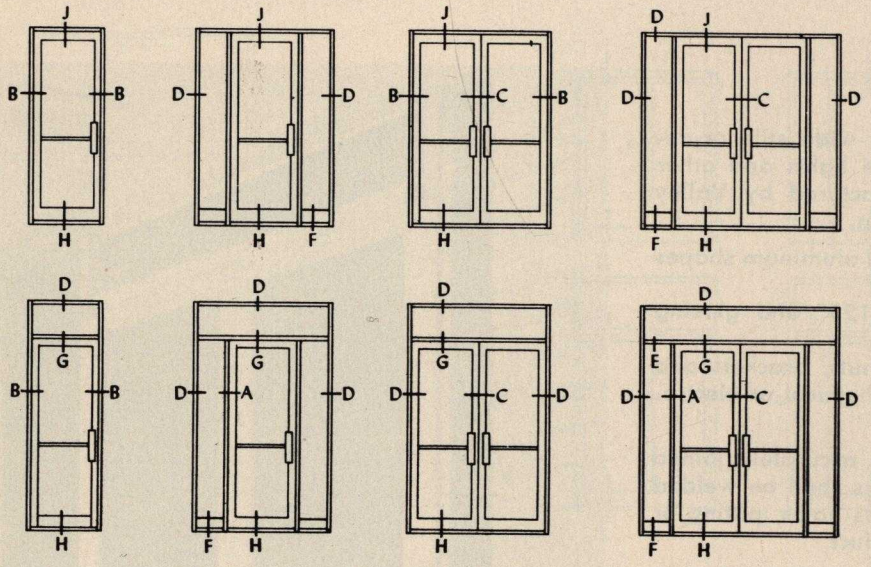
**PROTECTION:** Surfaces of the aluminum placed in contact with any material such as steel, concrete or any other material that contains corrosive chemicals the aluminum shall be protected by an approved method by the erection contractor.



**ERECTION:** All items under this section shall be installed in prepared openings and be set plumb, square and level and all properly aligned to insure proper operation and must be under the guidance of factory trained personnel.

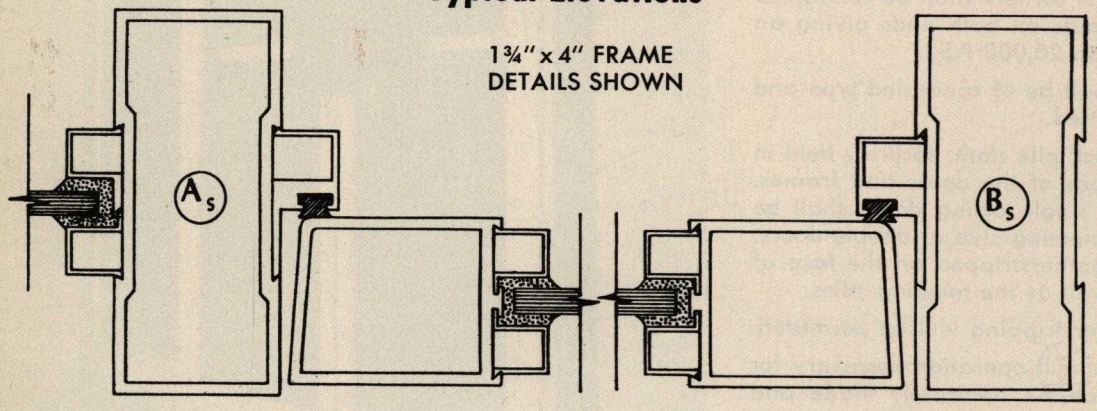
To insure proper operation the installation contractor and architect check and make any adjustments necessary for satisfactory operation.

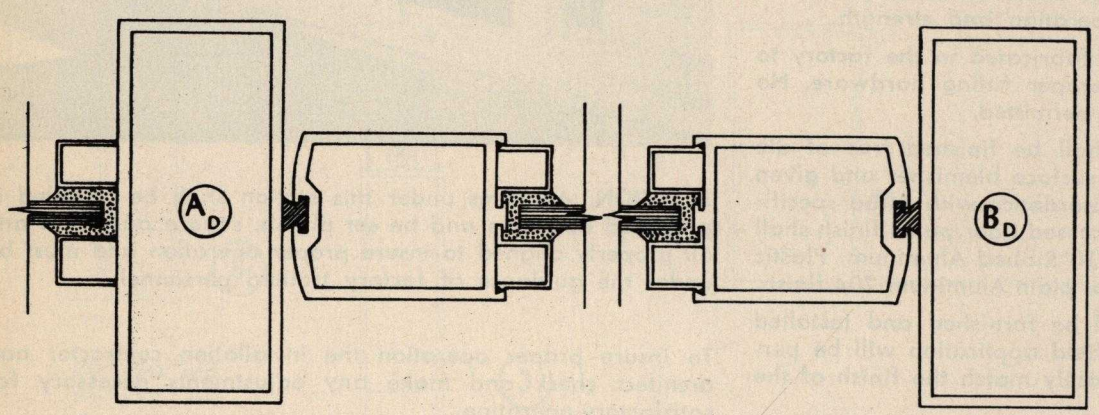
All material under this contract shall carry a guarantee of one year against manufacture defect and any failure occurring under these circumstances the material will be replaced without charge to the owner.

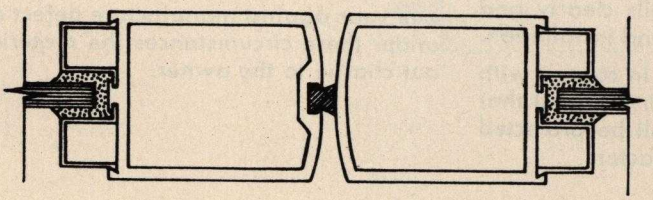



**Typical Elevations**

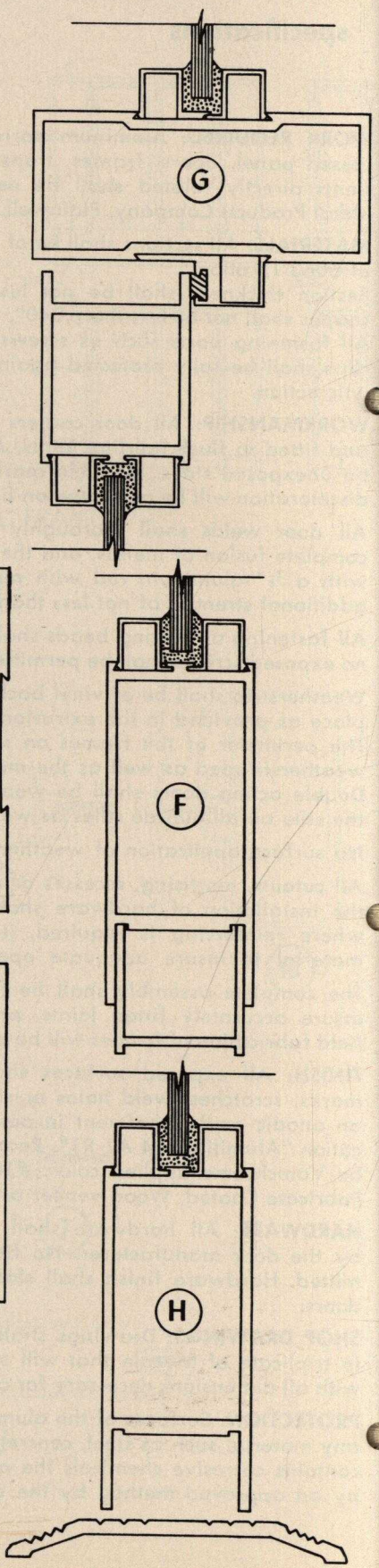
1¾" x 4" FRAME
DETAILS SHOWN



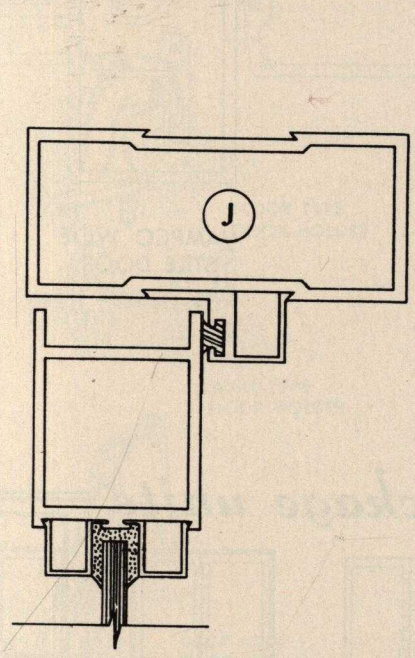



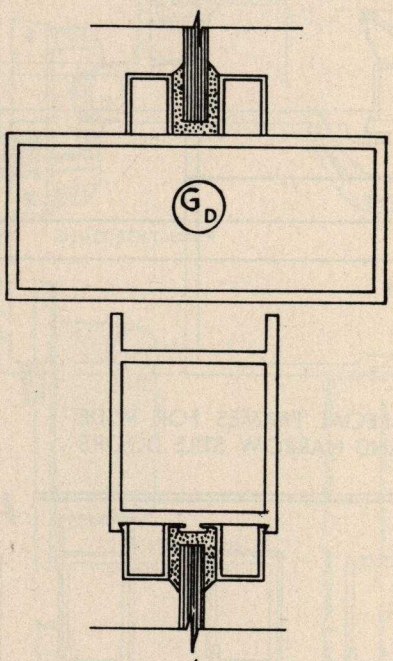



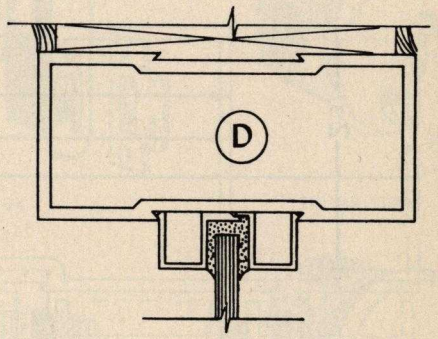
SMALL LETTER S. IN DETAIL IDENTIFICATION DENOTES SINGLE ACTION. SMALL LETTER D. DENOTES DOUBLE ACTION DOORS.

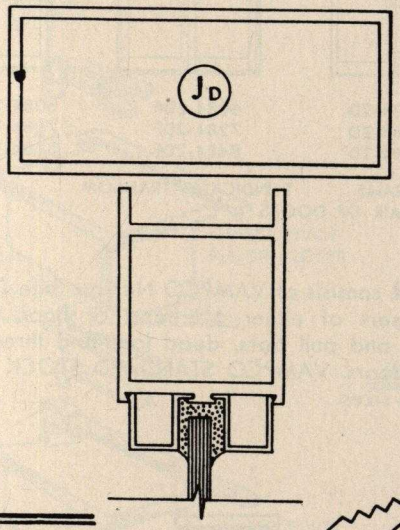


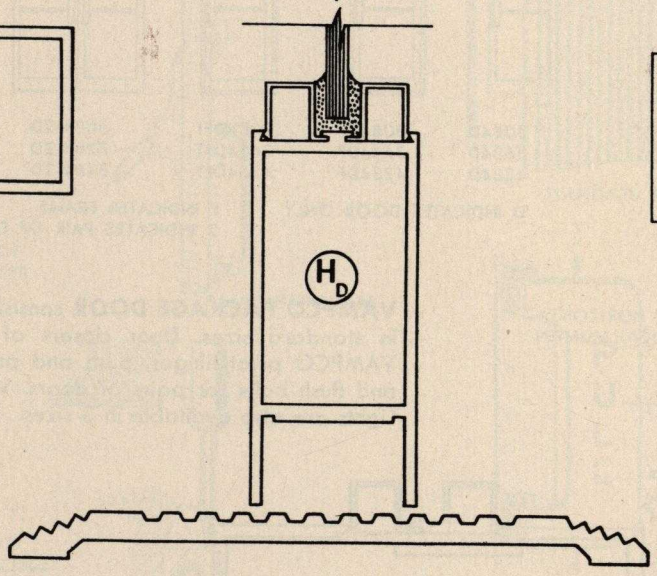
## NARROW STILE DOORS . . . . . ½ SIZE DETAILS

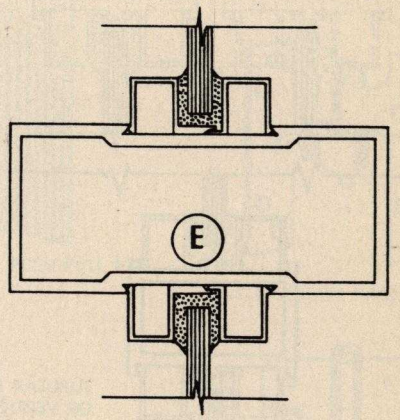


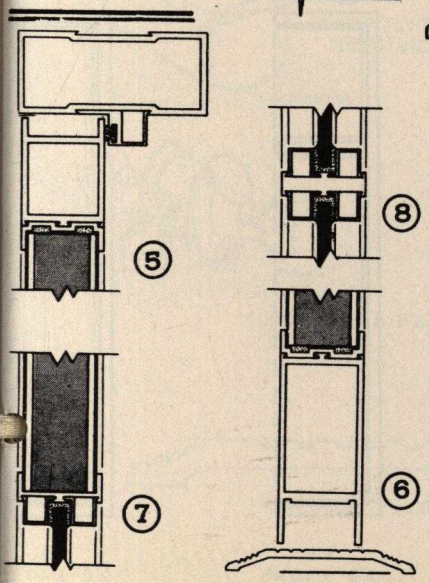



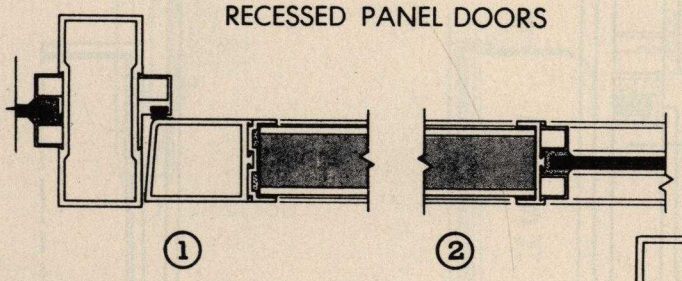



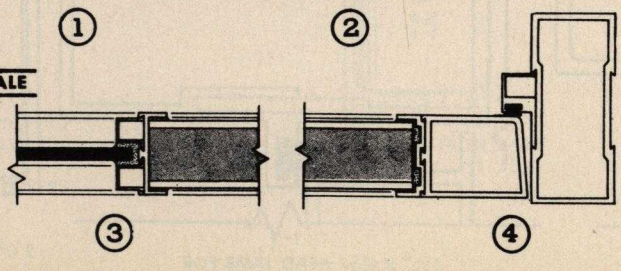



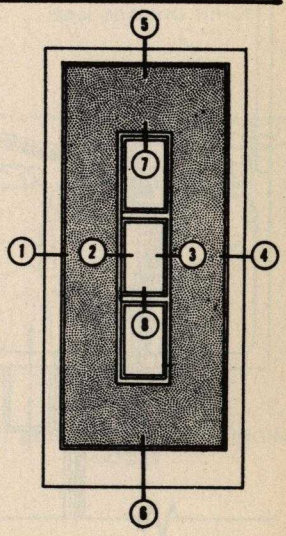

RECESSED PANEL DOORS



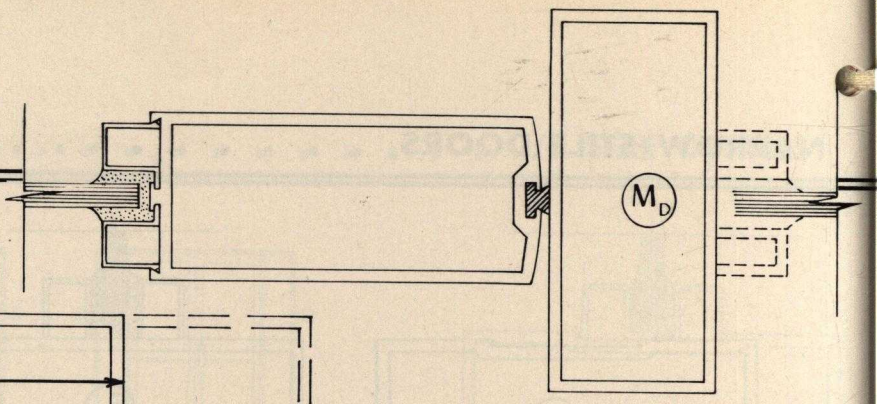

QUARTER SCALE



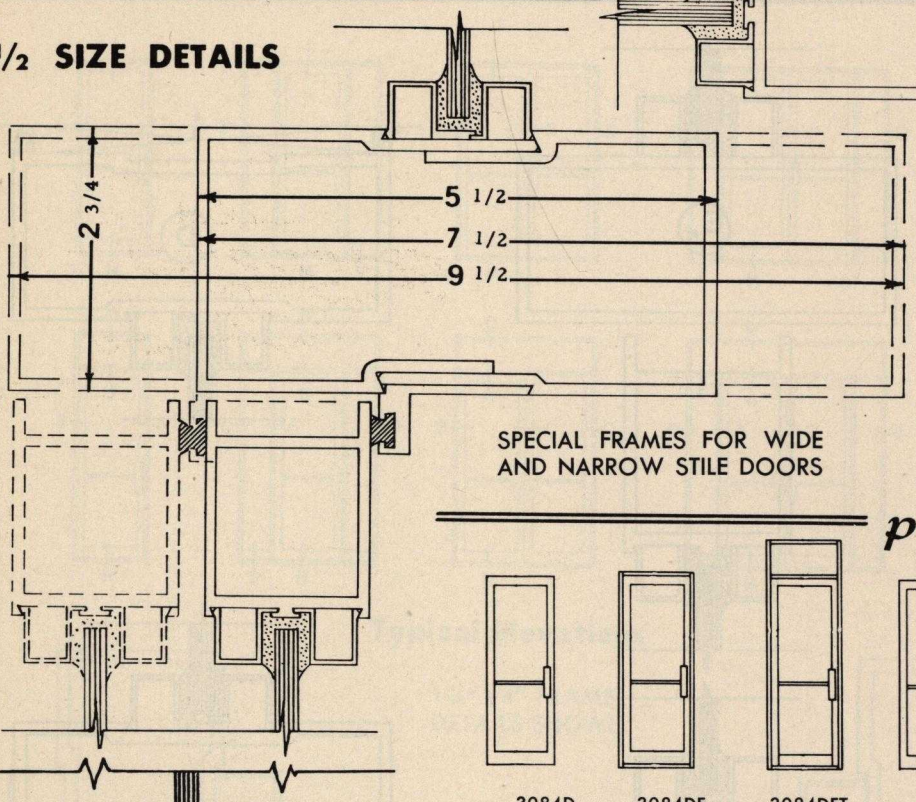



## ENTRANCE DOORS

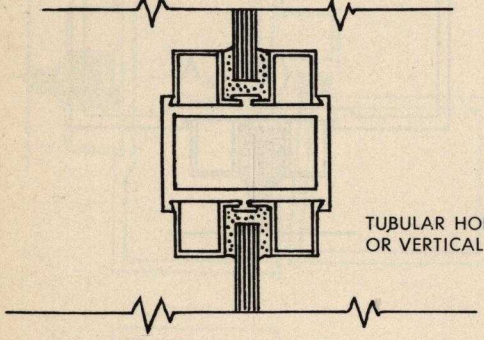
### ½ SIZE DETAILS




VAMPCO WIDE STILE DOOR

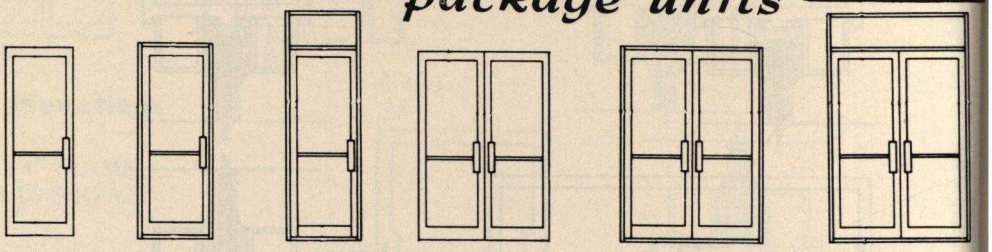



SPECIAL FRAMES FOR WIDE AND NARROW STILE DOORS



TUBULAR HORIZONTAL OR VERTICAL MUNTIN

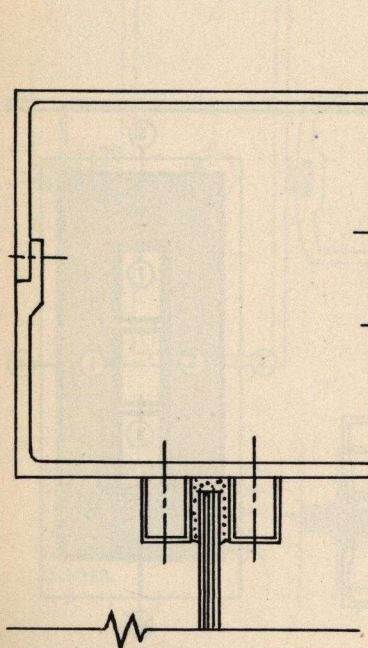
## *package units*



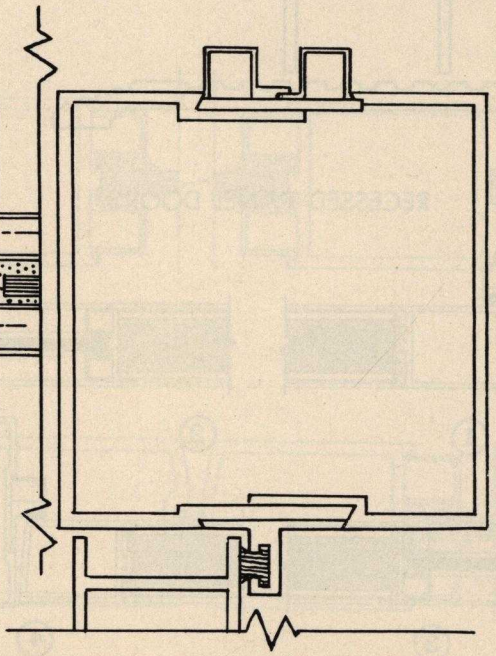
| 3084D | 3084DF | 3084DFT | 6084-2D | 6084-2DF | 6084-2DFT |
|---|---|---|---|---|---|
| 3684D | 3684DF | 3684DFT | 7284-2D | 7284-2DF | 7284-2DFT |
| 4284D | 4284DF | 4284DFT | 8484-2D | 8484-2DF | 8484-2DFT |

D INDICATES DOOR ONLY  F INDICATES FRAME  T INDICATES TRANSOM
2 INDICATES PAIR OF DOORS

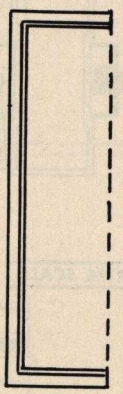
**VAMPCO PACKAGE DOOR** consists of VAMPCO Narrow Stile Doors in standard sizes. Door closers of either overhead or floor type, VAMPCO pivot hinges, push and pull bars, dead lock and threshold and flush bolts for pairs of doors. VAMPCO STANDARD STOCK Side Lights are also available in 3 sizes.



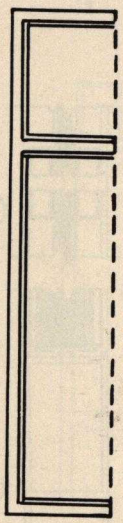
4" x 4" SELF-MATING CORNER POST



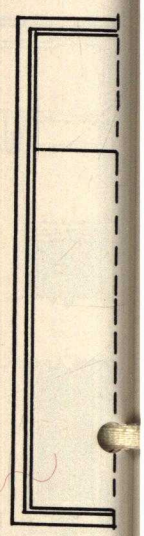
4½" x 4½" HEAD JAMB FOR CONCEALED OVERHEAD CLOSERS



V-1
2'0" x 7'2"



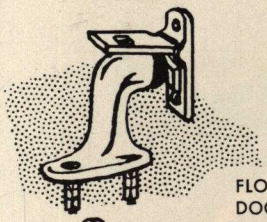
V-2
2'0" x 10'4"



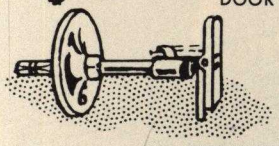
V-3
2'0" x 10'4"

VAMPCO

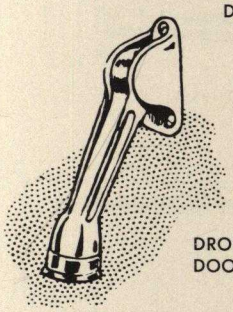
# *Aluminum doors*



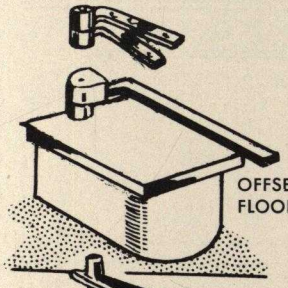
FLOOR TYPE
DOOR HOLDER



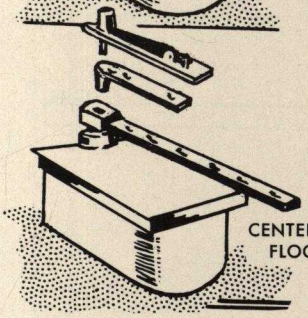
WALL TYPE
DOOR HOLDER



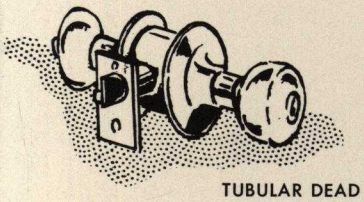
DROP ARM
DOOR HOLDER



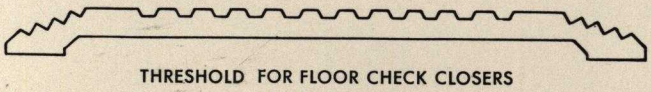
OFFSET PIVOT
FLOOR CLOSER



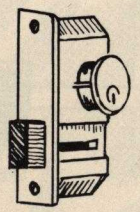
CENTER PIVOT
FLOOR CLOSER



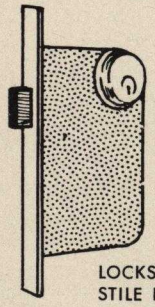
TUBULAR DEAD LOCK



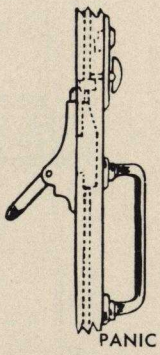
THRESHOLD FOR FLOOR CHECK CLOSERS



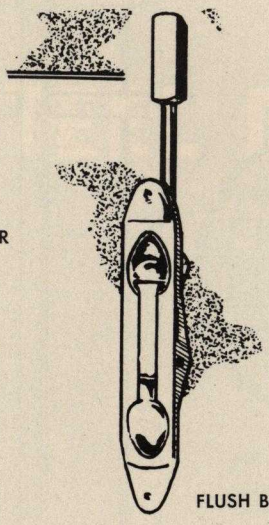
DEAD BOLT LOCK



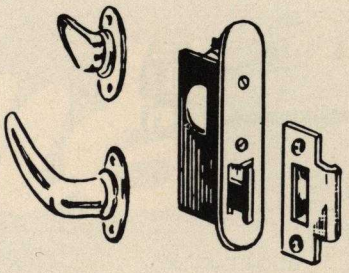
LOCKSET-WIDE
STILE DOORS



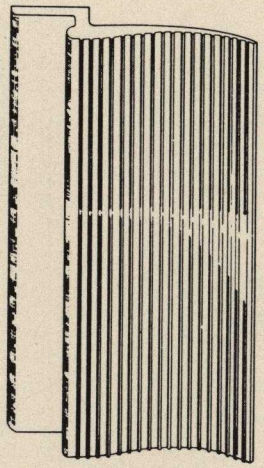
PANIC HARDWARE



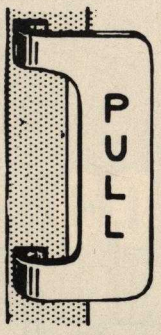
FLUSH BOLT



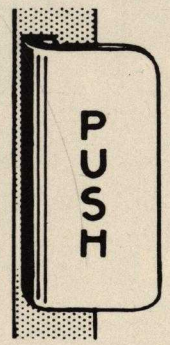
LATCH LOCK



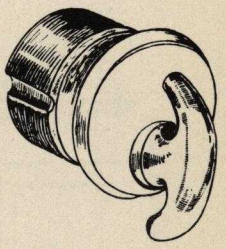
STANDARD PUSH-PULL BAR



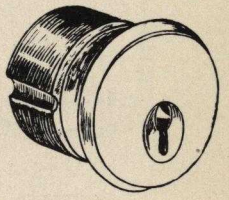

SPECIAL PULL BAR



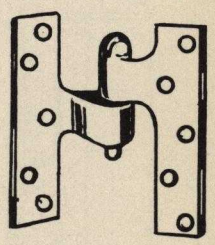

SPECIAL PUSH BAR



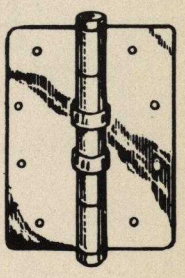
THUMB TURN



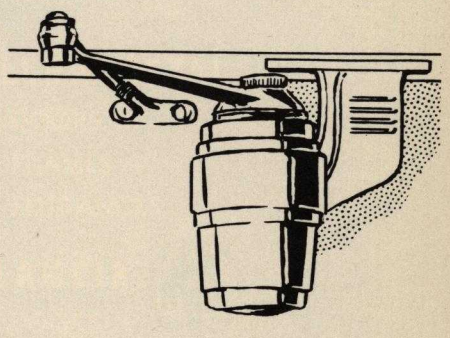
STANDARD LOCK CYLINDER



INTERMEDIATE PIVOT HINGE



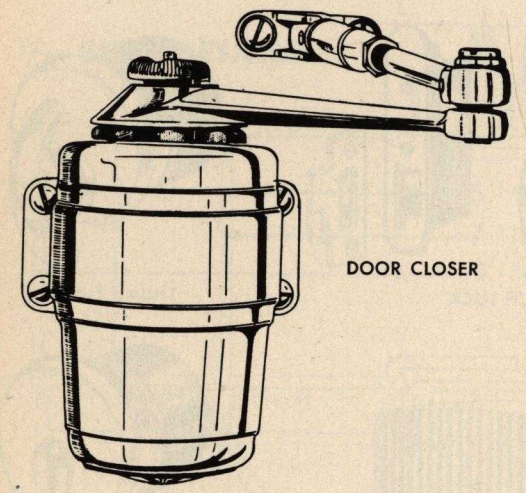
BALL BEARING HINGE



SOFFIT BRACKETS FOR OUTSWINGING
DOORS

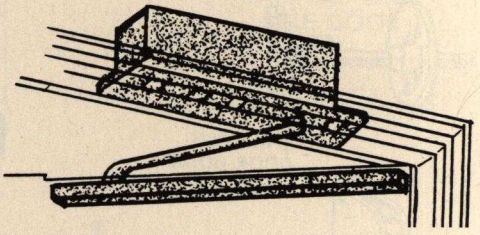
VAMPCO

# *Aluminum doors*

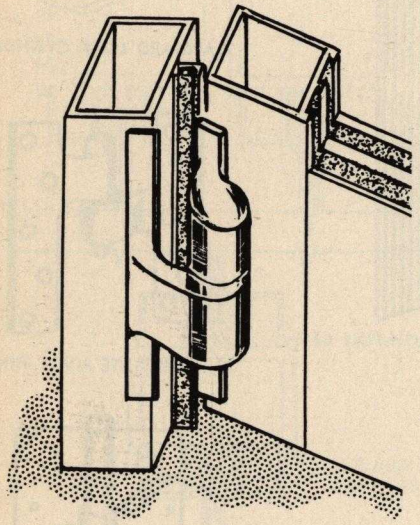


DOOR CLOSER

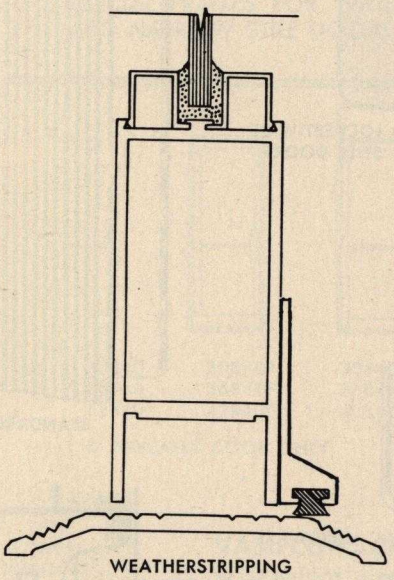
SPECIAL NAME PLATE PUSH BAR



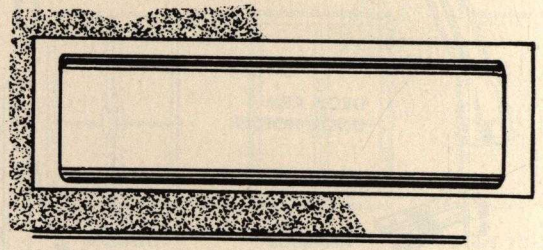
CONCEALED OVERHEAD CLOSER



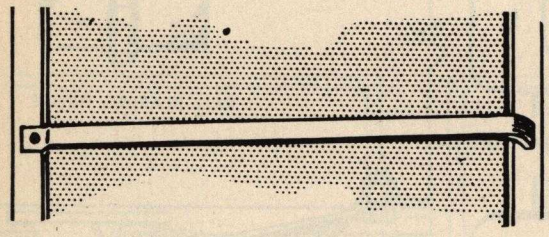
VAMPCO OFFSET PIVOT HINGE



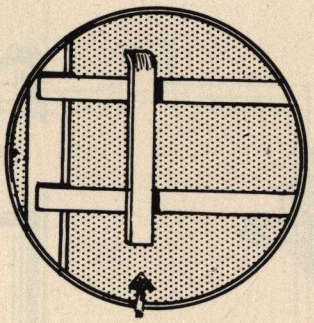
WEATHERSTRIPPING
BOTTOM RAIL



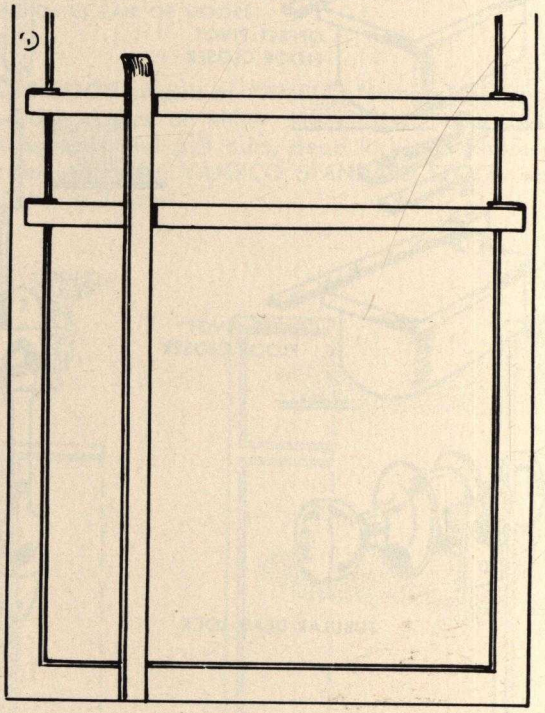
LETTER SLOTS



PUSH BAR



SPECIAL PUSH-PULL BAR



SPECIAL PUSH OR
PULL BAR SET

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